

Date: Friday, 8/25/2006 11:19:58 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MID TUBE ASSEMBLY
Job Number : 28337
Estimate Number : 10469
P.O. Number : N/A Part Number : D3391023
This Issue : 8/25/2006 S.O. No. : N/A Drawing Number : D3391 REV E
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : E
Previous Run : 28317 Material : N/A
Due Date : 9/22/2006 Qty: 1 Um: Each
Written By :
Checked & Approved By : 06-08-25
Comment : Est. A 06.10.20 New Issue KJ/EC
Est. B 06.02.10 ECN773 dwg rev.D EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25001100 Skidtube Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty Part Number Description Batch
1 D2500-1-100 Extrusion

BE 06-08-30

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375"

7-Remove .030" from Fwd indexing Ridge as per Dwg D3391

8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

9-Deburr

10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J"

12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391

13-Open .375" holes to .438"

BE 06-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 8/25/2006 11:19:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 28337

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

14-Deburr and blow out all chips from inside tube

BE 06-08-31

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-9-5

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M. 06/10/11 (1)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pm 06-10-21 (1)

6.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

B27656

A/R

Sikaflex-241/-291

m102107

Sikaflex expire date:

07-02-01

Pm 06-10-21 (1)

Start: 06-10-21 Time: 10:00am

Finish: 06-10-23 Time: 2:45pm

Pm 06-10-23 (1)

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

Pm 06-10-21 (1)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FR/4P 07/02/13 (1)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M. 07/02/14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 8/25/2006 11:19:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 28337

Part Number: D3391023

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 NAS1330C3KB116 Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
20	NAS1330C3KB116	Insert	19349

11.0 NAS1330C3KB166 INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

RivnuT

Pick:

Qty	Part Number	Description	Batch
10	NAS1330C3KB166	Insert	100732

12.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
Install inserts as per Dwg D3391

4

07/02/14 x1

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect each insert using DT8821

M 07/02/14

(1)

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

NIA ass't am tube

15.0 DC DOCUMENT CONTROL



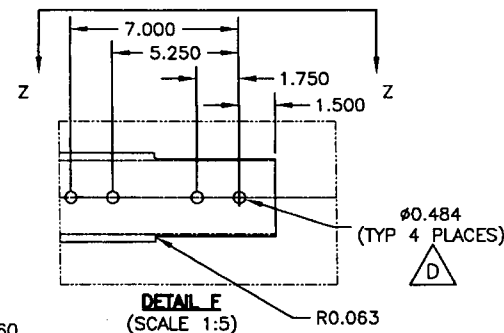
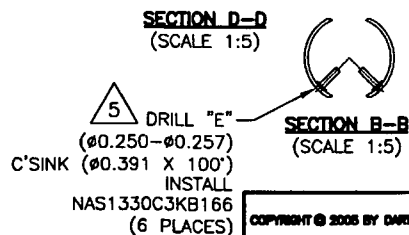
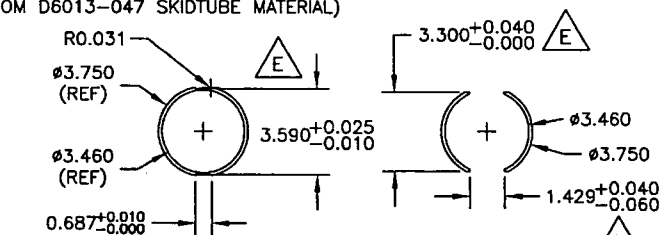
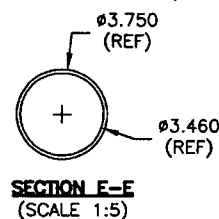
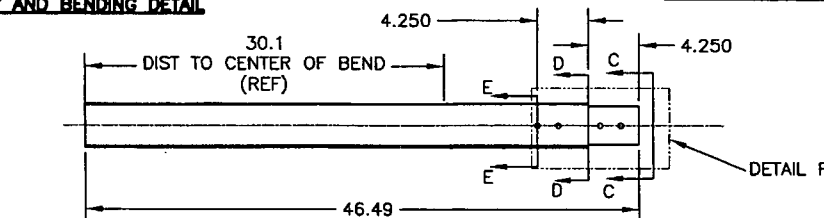
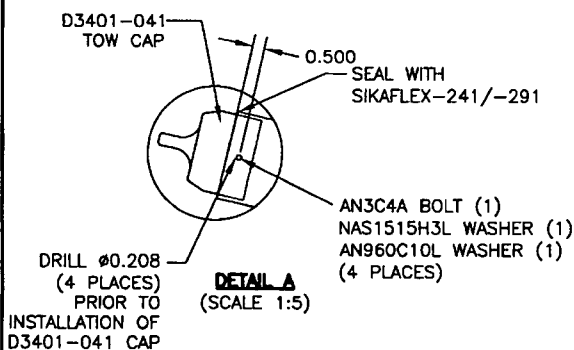
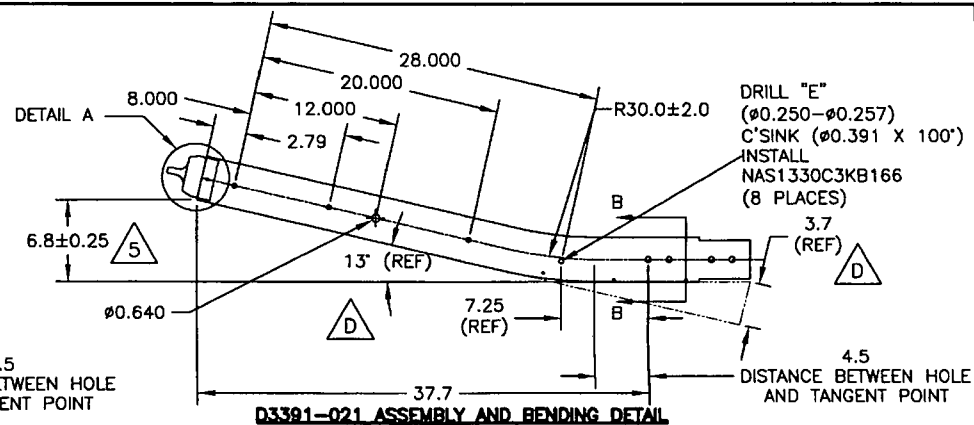
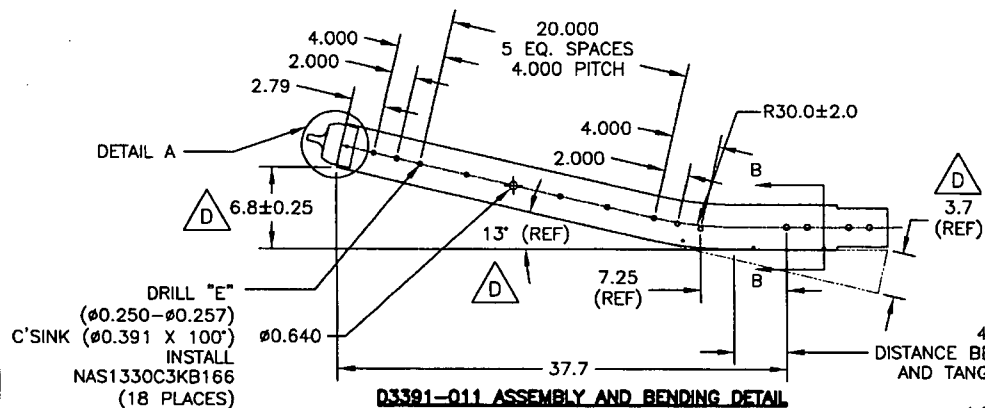
Comment: DOCUMENT CONTROL
Inspection Level 21

(1)
07/02/14

Job Completion



C20 7/02/14



RELEASED

06-05-03

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

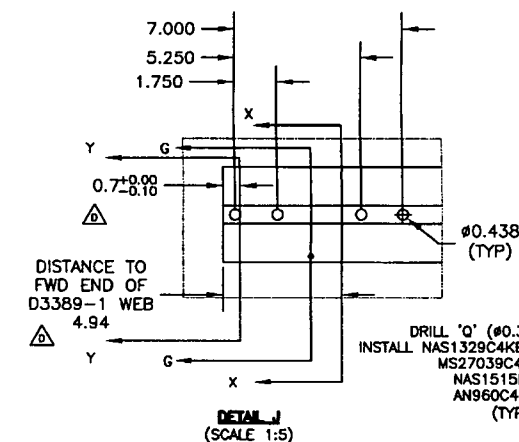
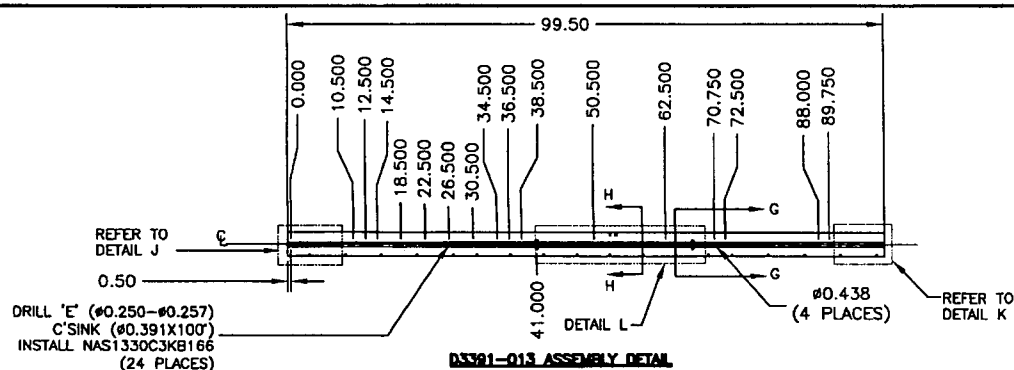
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

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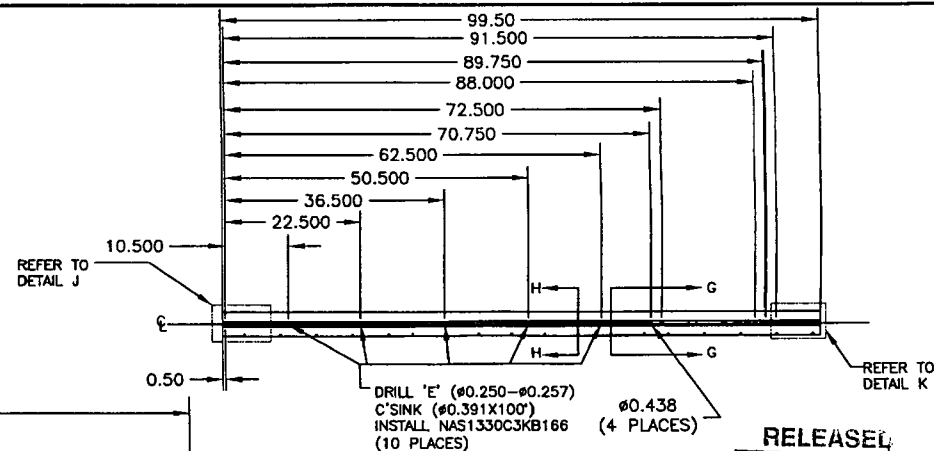
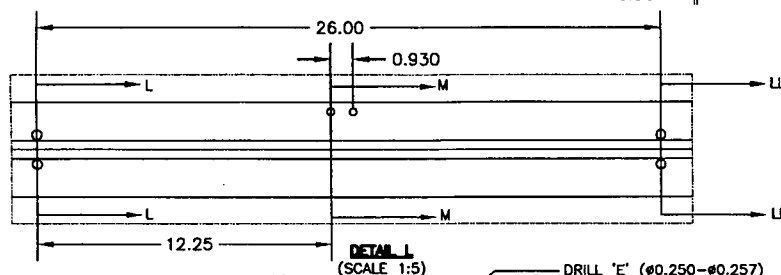
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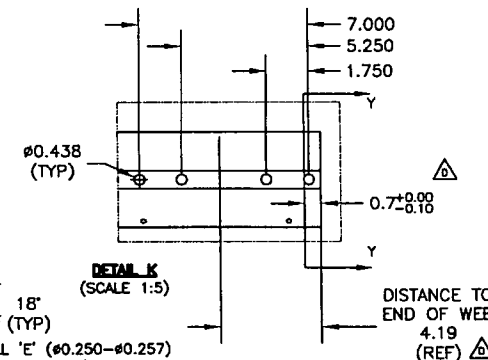
DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED #	APPROVED #	DRAWING NO. D3391	REV. E
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	SHEET 2 OF 5	SCALE 1:10



DRILL 'Q' (#0.332-#0.338)
INSTALL NAS1329C4KB140 INSERT
MS27039C4-08 SCREW
NAS1515H4L WASHER
AN960C416L WASHER
(TYP 4 PLACES)



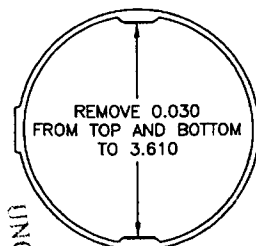
D3391-023 ASSEMBLY DETAIL



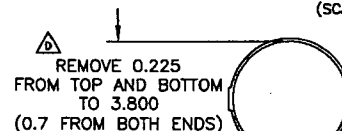
DRILL 'E' (#0.250-#0.257)
C'SINK (#0.391X100")
INSTALL NAS1330C3KB166
(10 PLACES)

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

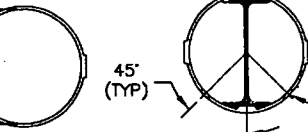
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(SCALE 1:4)



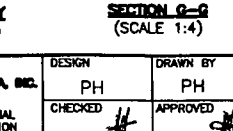
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(SCALE 1:4)



SECTION LL-LL
(SCALE 1:4)



SECTION Y-Y
(SCALE 1:4)



SECTION Q-Q
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)



D3391-013/-023 MID TUBE ASSEMBLY

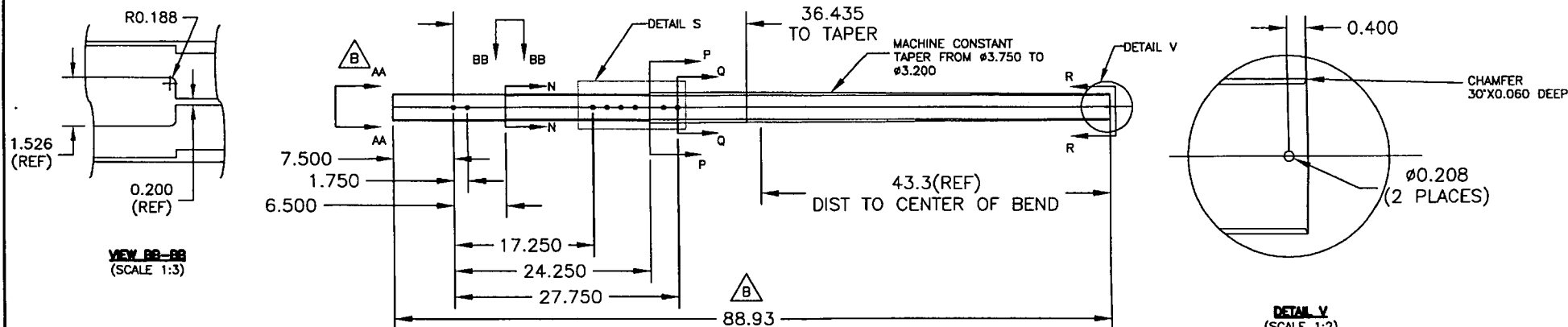
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QS

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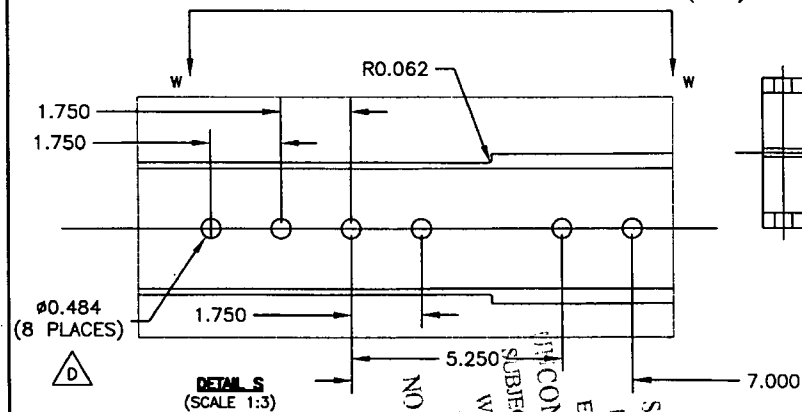
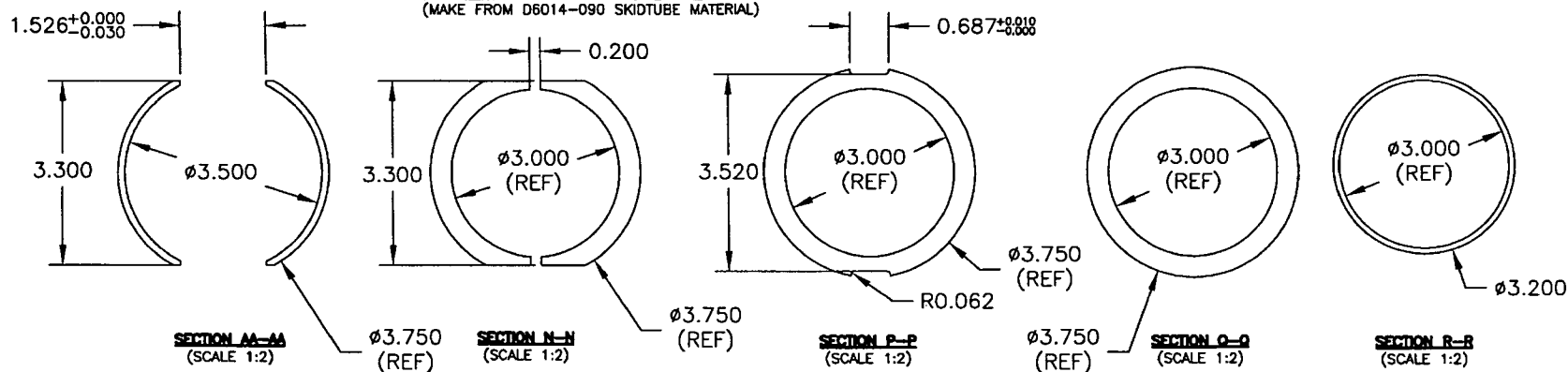
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CHECKED #	APPROVED #	DRAWING NO. D3391	SHEET 3 OF 5
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	SCALE 1:20	



D3391-3 AFT DRILLING AND CUTTING DETAIL
 (MAKE FROM D6014-090 SKIDTUBE MATERIAL)

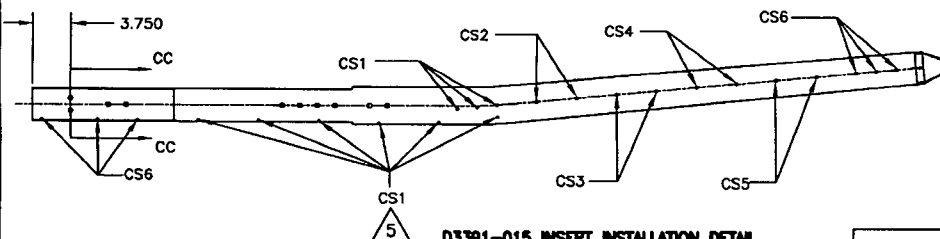
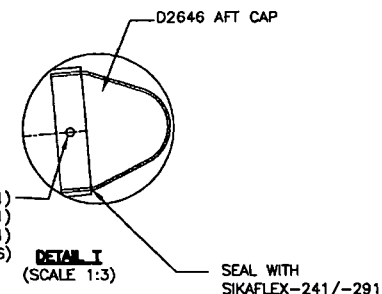
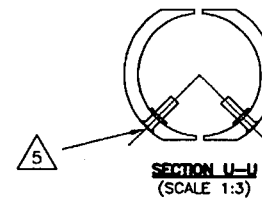
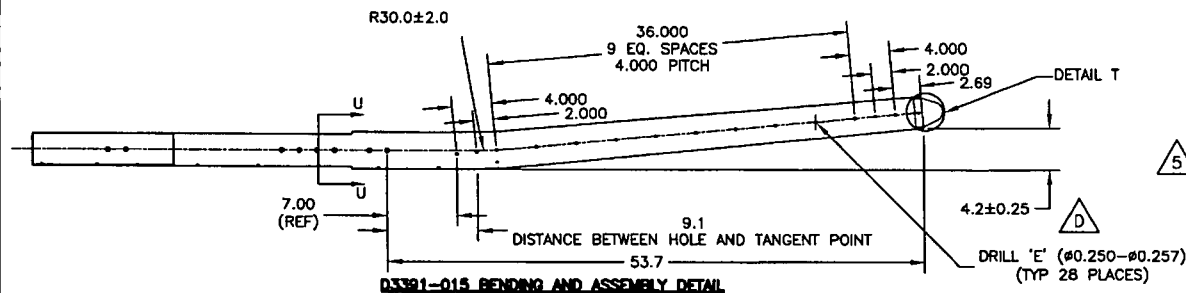


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CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. E
				D3391	SHEET 4 OF 5
DATE		TITLE			SCALE
06.04.25		412 FLOAT SKIDTUBE			1:12

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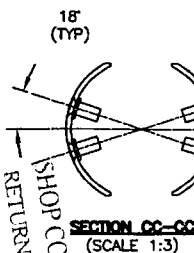


C'SINK AND INSTALL AESS10KBXXX AND/OR
NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS
FOLLOWS

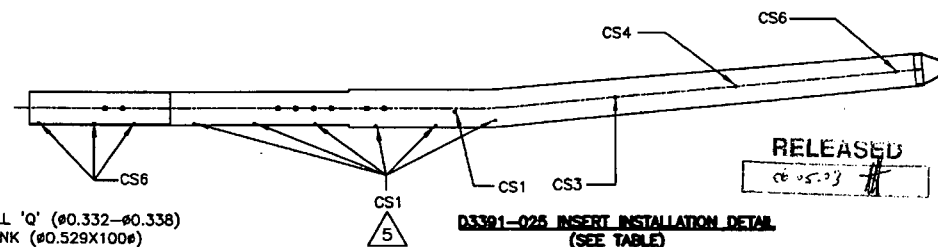
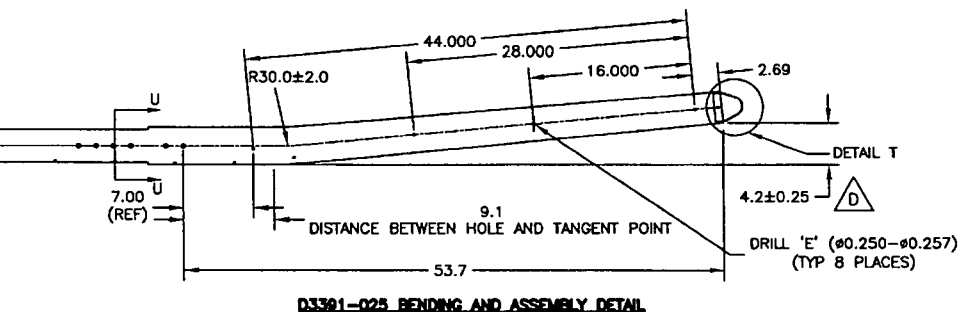
HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	4	2	Ø0.391	AESS10KB366
CS3	4	2	Ø0.391	NAS1330C3KB316
CS4	4	2	Ø0.391	NAS1330C3KB266
CS5	4	2	Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4	2	NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4	2	NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)



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CHECKED	APPROVED	DRAWING NO. D3391	SHEET 5 OF 5
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	

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